



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

005004

646.4001
Job Sheet 181950



Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/14/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Stores/Pkg-1		AUG 16 2018
110	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging1-1		AUG 20 2018
120	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC4		9-69
130	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1		9-69
135	DC	1 pcs	9/7/18	9/7/18	0.00	0.00	DC		DAS 9-69 AUG 23 2018
140	QC21-FG	1 Ea	9/7/18	9/7/18	0.00	0.00	QC21		21

Part Op 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4001

AUG 23 2018
21
9-69

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5031229
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5078331
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5078332
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5078333
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5060985
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5060987
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5049887
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5059056
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	5065343
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5079063
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5050053
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5063686
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5043544
646.3710	Doubler	1 Ea (1 ea)	90-Start up Operation	5040604
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5038795
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5020726
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	5042029
646.3714	Gusset	1 Ea (1 ea)	90-Start up Operation	5038824
646.3715	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	5035990
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5039275
646.3717	Doubler	1 Ea (1 ea)	90-Start up Operation	5026842
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5038803

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube</td><td style="width:15%;">Cross tube</td><td style="width:15%;">Water Jet</td><td style="width:15%;">Engineering</td></tr> <tr> <td>Machining</td><td>Small Fab</td><td>Prod. Eng. Coord.</td><td>Quality</td></tr> <tr> <td>Thermoforming</td><td>Finishing</td><td>Rec/Store/Packaging</td><td>Other</td></tr> <tr> <td>Large Fab</td><td>Composite</td><td>Supplier</td><td></td></tr> </table>				Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier																																																																																								
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646.3719	Doublers	2 Ea (2 ea)	90-Start up Operation	5061543
646.3810	Bracket	2 Ea (2 ea)	90-Start up Operation	5067214
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5057883
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation	5067236
646.3813	AS350 Strut Bracket	1 Ea (1 ea)	90-Start up Operation	5037064
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5065272
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5041250
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5026145
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	7126060
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	7100671
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5063624
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5081929
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5092170
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5070145
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5048376
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5038732
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation	5056462
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation	5060062
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5071342
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5048402
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5080637
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5065262
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5027516
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5065264
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation	5071733
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation	5042004
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	50153848
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation	71134063
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation	7124089
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation	7123425
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5044234
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation	5089340
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5089365
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation	5020620
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5065341
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5004859
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5041925
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5050050
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5016508
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation	5071834
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5049832
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5049833
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5071413
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5000680
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5032684
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation	5103666
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation	5075330
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5083558
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	711983369

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	304	0
	600.0990	1	15	0
	600.0991	1	15	0
	600.1012	1	19	0
	600.1013	5	49	0
	646.2910	1	30	0
	646.3001	1	4	0
	646.3110	1	6	0
	646.3210	1	19	0
	646.3301	1	4	0
	646.3510	1	22	0

005004

Job
181950

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

646.3511	1	27	0
646.3610	1	53	0
646.3710	1	37	0
646.3711	1	25	0
646.3712	1	20	0
646.3713	1	26	0
646.3714	1	39	0
646.3715	2	43	0
646.3716	1	29	0
646.3717	1	50	0
646.3718	2	42	0
646.3719	2	14	0
646.3810	2	34	0
646.3811	1	8	0
646.3812	2	16	0
646.3813	1	45	0
646.3910	4	26	0
646.3911	1	42	0
646.3912	4	42	0
646.3913	1	42	0
646.9410	1	104	0
647.0112	2	114	0
647.7703	2	7	0
650.9201	2	25	0
AN3-11A	10	275	0
AN3-12A	2	128	0
AN3-13A	1	123	0
AN3-3A	4	484	0
AN3-4A	10	191	0
AN3-5A	2	428	0
AN3-6A	2	48	0
AN316C4R	2	49	0
AN44-5A	2	19	0
AN4C7A	2	159	0
AN665-34R	2	29	0
CCR264SS3-02	36	237	0
CR3213-5-3	14	141	0
MS20426AD5-7	2	1,067	0
MS20470AD5-5.5	8	261	0
MS20470AD5-6	8	1,046	0
MS20470AD5-7	3	155	0
MS21042L08	2	3,152	0
MS21042L3	63	4,275	0
MS21042L4	2	5,856	0
MS21047-3	18	98	0
MS24693-C278	5	170	0
MS24694-S51	5	179	0
MS24694-S54	2	85	0
MS24694-S55	3	241	0
MS27039-08-13	2	203	0
MS27039-1-10	2	340	0
MS27039-1-12	6	149	0
MS27039-1-16	24	179	0
MS27039-1-19	22	349	0
MS27039-1-20	2	123	0
MS27039-1-21	4	34	0
NAS1149F0332P	144	894	0
NAS1149F0363P	2	628	0
NAS1149F0432P	4	2,161	0
NAS1149FN832P	4	2,566	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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NOTES:

1. AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.
2. INSTALL F/N 14 WITH F/N 52 & 53.
3. 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.
4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.
5. REUSE FASTENERS FROM F/N 1.
6. USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.
7. AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.
8. INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.
9. NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

REFERENCE ONLY

UNINCORPORATED ECN(S)

05304

5	5	5	78	601.3875	SCREW	AS27039-1-19				
1	1	1	77	646.9410	SHIM	AS27039-1-19				
	4	4	76	601.2764	WASHER	NAS1149F0363P				
	2	2	75	601.2973	LOCKNUT	MS21042-08				
	2	2	74	601.2988	SCREW	MS27039-0813				
	2	2	73	601.2943	LOCKNUT	MS21042-0				
	2	2	72	601.3128	NUT	AN316C4R				
	2	2	71	601.3209	LOCKNUT	MS21042-4				
	4	4	70	601.2638	WASHER	NAS1149F0432P				
	2	2	69	601.2669	BOLT	AN4C7A				
	2	2	68	601.3119	CLEVIS	AN665-34R				
	2	2	67	601.3121	EYE BOLT	AN44-5A				
	2	2	66	650.9201	EYE BRACKET ASSY					
REF	REF	REF	65	647.5701	GPS MOUNT KIT					
		2	64	601.3151	WASHER	NAS1149F0363P				
		2	63	601.2911	SCREW	MS24694553				
	24	24	62	601.2637	SCREW	MS27039-1-16				
2	2	2	61	601.2763	BOLT	AN3-12A				
	1	1	60	646.3913	SHIM					
	4	4	59	646.3912	SHIM					
	1	1	58	646.3911	SHIM					
	4	4	57	646.3910	SHIM					
	5	5	56	600.1013	PRIMER					
8 FT	8 FT	55	600.0129	VHB TAPE						
1	1	1	54	600.1012	SEALANT	PR-1405 CLASS B				
	1	1	53	600.0991	MAGNABOND 6398 PART B					
	1	1	52	600.0990	MAGNABOND 6398 PART A					
6	10	10	51	601.2826	BOLT	AN3-11A				
		2	50	646.3814	WIPER BRACKET					
		2	49	601.2910	SCREW	MS27039-1-18				
2		2	48	601.1365	SCREW	MS27039-1-10				
2		2	47	646.3719	DOUBLER					
	2	2	46	646.3718	CUSTOM WASHER					
1		1	45	646.3717	DOUBLER					
	22	2	44	601.1948	SCREW	MS27039-1-19				
	2	2	43	601.1952	SCREW	MS27039-1-20				
	4	4	42	601.1956	SCREW	MS27039-1-21				
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 0219, 0223, 02719 & 02745	03/08/2010	P. BRAVO
B	INCORPORATED ECN 0304, 0309, & 0431	11/04/2014	P. BRAVO
C	INCORPORATED ECN 0508	09/09/2015	P. BRAVO

		2		2	41	601.2829	SCREW	MS24694554		
		2		2	40	601.2831	RIVET	MS20426AD5-7		
		1		1	39	646.3716	GAUGE BRACKET			
		6		6	38	601.1953	SCREW	MS27039-1-12		
	2	2		2	37	646.3715	STRUT DOUBLER			
	2	2		2	36	601.2824	BOLT	AN3-5A		
12	36			36	35	601.2277	RIVET	CR03445-3-02		
6	18			18	34	600.0795	NUTPLATE	MS21047-3		
3	3			3	33	601.2565	RIVET	MS20470AD5-7		
1	1			1	32	646.3813	STRUT BRACKET			
4	4			4	31	601.2822	BOLT	AN3-3A		
2	2			2	30	646.3812	GUSSET BRACKET			
8	8			8	29	601.2564	RIVET	MS20470AD5-6		
1	1			1	28	646.3714	GUSSET			
	1	1		1	27	646.3610	FILLER			
	3	3		3	26	601.2830	SCREW	MS24694555		
	2	2		2	25	601.2825	BOLT	AN3-6A		
	1	1		1	24	646.3811	RADIUS BLOCK			
	1	1		1	23	646.3712	CLIP			
	1	1		1	22	646.3711	CLIP			
8	8			8	21	601.2832	RIVET	MS20470AD5-5		
14	14			14	20	601.2020	RIVET	CR3213-5-3		
4	6	4	6	10	19	601.2823	BOLT	AN3-4A		
	1	1		1	18	601.2827	BOLT	AN3-13A		
	5	5		5	17	601.2912	SCREW	MS24694551		
1	1			1	16	646.3713	GUSSET			
1	1			1	15	646.3210	SUPPORT			
	1	1		1	14	646.3710	DOUBLER			
	1	1		1	13	646.3110	CHANNEL			
14	10	8	53	6	61	12	601.1624	LOCKNUT	MS21042-3	
16	32	18	120	16	144	11	601.1607	WASHER	NAS1149F032P	
				1	10	646.3410	LH WIPER DEFLECTOR			
				1	9	646.3411	RH WIPER DEFLECTOR			
		2		2	8	647.7703	STRUT ASSY			
		2		2	7	647.0112	STRUT BRACKET			
	1	1		1	6	646.3511	STRUT			
	1	1		1	5	646.3510	STRUT			
2		2		2	4	646.3810	BRACKET			
		1		1	3	646.2910	DEFLECTOR			
	1	1		1	2	646.3001	LOWER CUTTER ASSY			
		1		1	1	646.3301	UPPER CUTTER ASSY			
X						646.4006	LOWER CUTTER FIXED PROVISIONS			
	X					646.4005	LOWER CUTTER REMOVABLE PROVISIONS			
		X				646.4004	FIXED PROVISIONS KIT			
			X			646.4003	CABLE CUTTERS KIT WITHOUT FIXED PROVISIONS			
				X		646.4002	AS350 WIPER DEFLECTOR KIT			
					X	646.4001	AS350 CABLE CUTTERS KIT			
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		NEXT ASSY (S)		ORIGINAL DATE MSD-DA-111-08-21-08 DESIGNED BY S. HUFF DRAWING APPROVAL P. BRAVO DATE 08-21-08		DART AEROSPACE APICAL INDUSTRIES, INC. DBA DART AEROSPACE 9030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
AS350 CABLE CUTTERS KIT						UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.001 ANGLES ±.5°	
SCALE NONE		ENGR. NO. 646.4000		REV. C		SHEET 1 OF 5	

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